

**Work Order ID 59070**

May 26, 2010 7:43:50 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 5/26/10

Start Qty: 6.00



Cust Item ID:

Required Date: 5/27/10

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: 

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B10-5-06

(9)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-5-06

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Item ID: D3929-041

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Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 5/26/10

Start Qty: 6.00



Cust Item ID:

Required Date: 5/27/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Large Fab  
Memo  
Weld bushings D3907-1 as per dwg D3929

0.00



Large Fab

Memo

0.00

Large Fab

316L rod batch: M113328

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*S 10/06/03*

*(49)*

*10/06/03 (9x)*

*(9) 10.06.04*

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Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 5/26/10 Start Qty: 6.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/06/04

(XS)

-01

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 10/06-07

(9)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07  
ME  
10-6-7

# Picklist Print

May 26, 2010 7:43:48 AM

Page 1

Work Order ID: 59070

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Comments:

Start Date: 5/26/10

Required Date: 5/27/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

52.1800

0.45

2.842105

4.5



304/316 0.125 Sheet



13105-26

Location

Loc Qty

Loc Code

MAT

52.18

114488

52.18

114488

9

D3907-1

Manufactured

No

130

Each

48.0000

2

12



Bushing



10/06/03

Location

Loc Qty

Loc Code

WA

48

57242

7

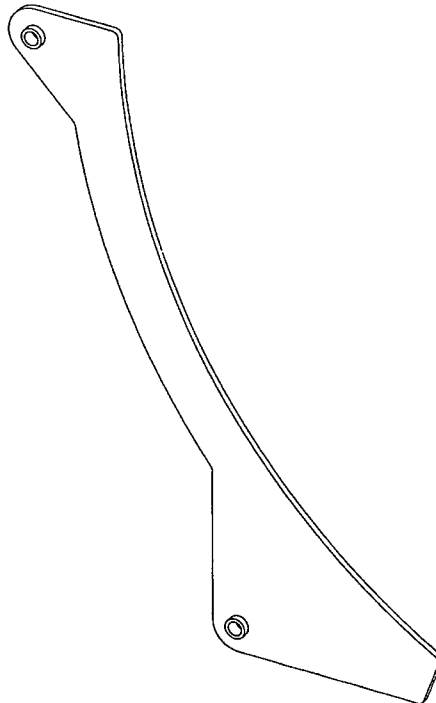
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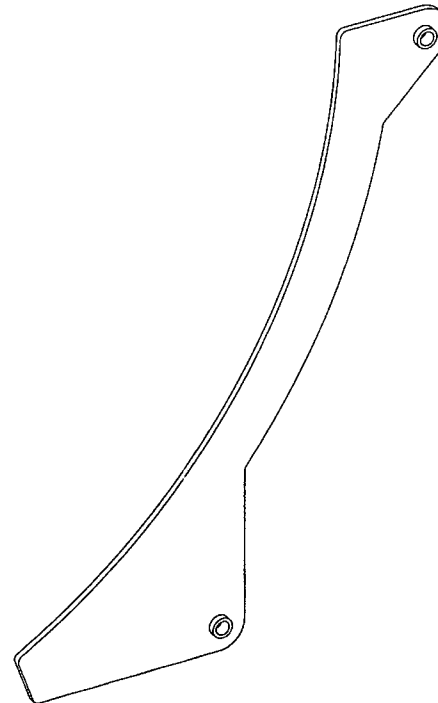
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

*26 59070*

**RELEASED**  
*9/6/04*

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. A	
CHECKED		D3929	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED		GUSSET ASSEMBLY	NTS	
DE APPR.		DATE 09.04.03		
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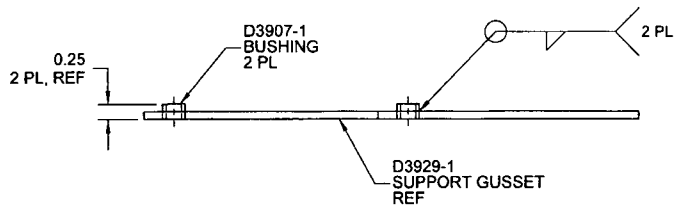
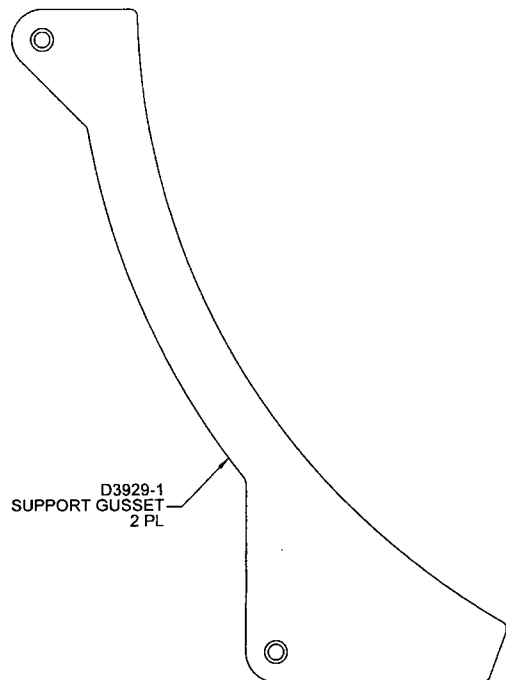
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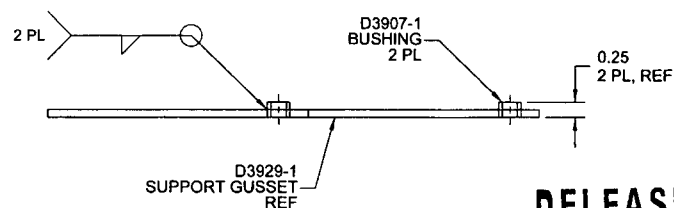
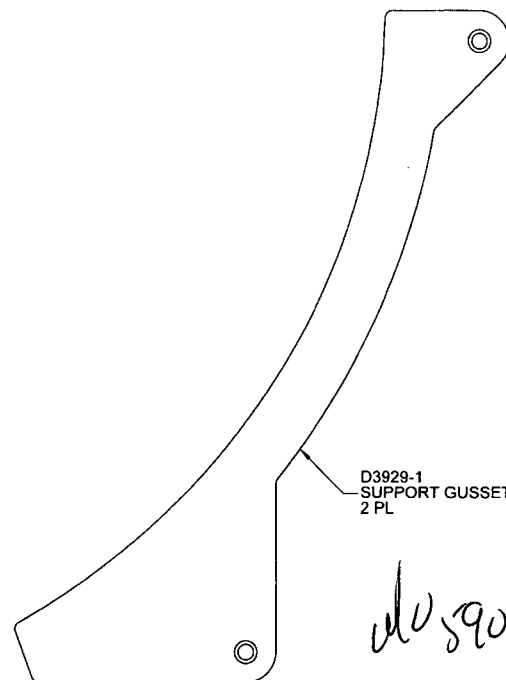
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B

A



**D3929-041 GUSSET ASSEMBLY**

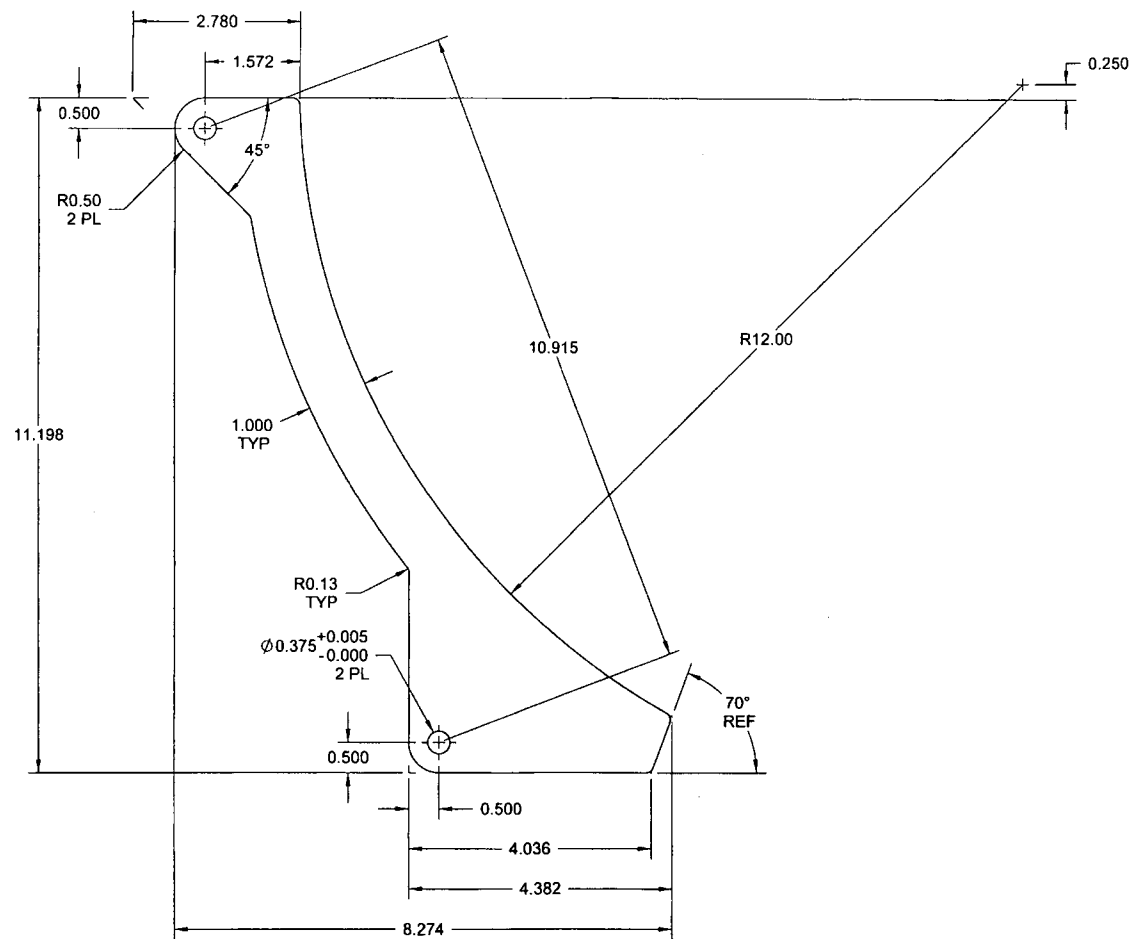


**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22 MD

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3929	SHEET 2 OF 3
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8 7 6 5 4 3 2 1



**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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**RELEASED**  
9/6/12 JWB

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59070